

Work Order ID 86202

86202

Page 1

June-22-12 3:03:51 PM

Item ID: D139-799-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cargo Door Hinge

Stop *NS2*

Start Date: 22/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9613

A

IIN-D139-799

F

100

0.00

DAS
1C

1000

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D139-799-013
CHG005

0.00

for MLJ 12-8-2
(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/7/26 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D139-799-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cargo Door Hinge

Stop ***NS2***

Start Date: 22/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D139-799-013

Location: 23

PPP rev: D

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control



sf

1 12/09/17

12/9/18

11/20/18

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 86202

86202

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge




Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD
IPP REV:C AS PER DSI9567 revA 11.10.17 DD VERF:EC IPP
REV:D 12.01.19 per iin rev.f ecn 12-507 DD verf:EC IPP REV:E
12.06.14 per ecn 12-606 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status															
D4632-1 *D4632-1* Striker Plate		Manufactured	No			110	Each	0.0000	 2																			
D4632-2 *D4632-2* Striker Plate		Manufactured	No			110	Each	0.0000	 2																			
MS21042L08 *MS21042L08* Nut		Purchased	No			110	Each	907.0000	 16																			
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST300</td><td>107</td><td></td></tr><tr><td>121524</td><td>107</td><td></td></tr><tr><td>ST317</td><td>800</td><td></td></tr><tr><td>122141</td><td>800</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST300	107		121524	107		ST317	800		122141	800	
Location	Loc Qty	Loc Code																										
ST300	107																											
121524	107																											
ST317	800																											
122141	800																											
MS24694-S4 *MS24694-S4* Screw		Purchased	No			110	Each	108.0000	8	16																		
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>Mezz</td><td>108</td><td></td></tr><tr><td>11788</td><td>100</td><td></td></tr><tr><td>9370</td><td>8</td><td></td></tr></table>														Location	Loc Qty	Loc Code	Mezz	108		11788	100		9370	8				
Location	Loc Qty	Loc Code																										
Mezz	108																											
11788	100																											
9370	8																											

B86202 rd 88

B86202 vrf 88

M1224525f 88

12/8/12 88

710 ->

W/O: 86202

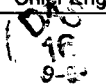
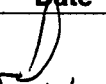

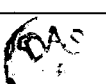
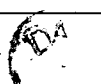


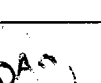
WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D139-799-013 PAR #: _____ Fault Category: Prod Eng. com. NCR: Yes No DQA: Yes Date: 12/09/18
 Resolution: _____ Disposition: Review QA: N/C Closed: Yes Date: 12/9/18

NCR: 12-1820

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/09/17	#100	wrong Part. Should be MS24694-S47 Not MS24694-S4. R.C. w/o + Bom Mit	 ASZ012 12/09/17	Remove + replace with correct parts MS24694-S47 B MS24694-S47 12/22/17	 12/9/17	 12/09/17	 ASZ012 12/09/17	 12/09/17
	R.C.	create correctly INSUFFICIENT VERIFICATION		correctly update w/o + Bom ADD copy of updates Bom As Req.	 12.09.18		 ASZ012 12/09/17	 12/09/17

NOTE: Date & initial all entries

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Work Order ID: 86202

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-07

Purchased

No

110

Each

79.0000

8
**

16

M/22563

[Handwritten signature]

MS27039-08-07

Screw

Location

Loc Qty

Loc Code

Mezz

79

4969

79

110

Each

1,785.000

8
**

16

[Handwritten signature]

[Handwritten signature]

NAS1149D0332J

Purchased

No

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

ST297

982

121708

982

ST298

803

105793

12

110985

4

117087

89

119042

16

119717

181

120644

7

121011

494

110

Each

575.0000

8
**

16

[Handwritten signature]

NAS1149DN832J

Purchased

No

NAS1149DN832.J

WASHER

Location

Loc Qty

Loc Code

ST298

575

119717

41

120422

534

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86202

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

D2585

Manufactured No

110 Each

72.0000

0 2

**

D2585
Mounting Channel

Location

Loc Qty

Loc Code

ST011

72

73297

2

82029

20

83369

6

85425

44

D2586

Manufactured No

110 Each

100.0000

0 2

**

D2586
Door Latch

Location

Loc Qty

Loc Code

ST203A

100

78833

1

83893

99

D2621

Manufactured No

110 Each

23.0000

0 2

**

D2621
Latch Plate, 350 Spacepod

Location

Loc Qty

Loc Code

ST013

23

78991

23

D3552-28

Manufactured No

110 Each

19.0000

0 2

**

D3552-23
Door Prop

Location

Loc Qty

Loc Code

ST272A

19

74847

6

80347

1

83586

12

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86202

86202

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

D3622-1

Manufactured No

110 Each

19.0000

**

D3622-1
Ball Stud

Location

Loc Qty

Loc Code

ST058

19

82072

19

Manufactured No

110 Each

13.0000

**

D3622-3

D3622-3
Ball Stud

Location

Loc Qty

Loc Code

ST058

13

53951

4

82595

9

Manufactured No

110 Each

4.0000

**

D4072-1

D4072-1
Airframe Hinge

Location

Loc Qty

Loc Code

ST090

4

82356

4

Manufactured No

110 Each

22.0000

**

D4072-3

D4072-3
Airframe Hinge Backing Plate

Location

Loc Qty

Loc Code

ST090

22

78529

2

82837

20

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86202

86202

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

D4072-5

Manufactured No

110 Each

1.0000

Spr ***D4072-5***
Bushing

**

8
B 86206sf

Location

Loc Qty

Loc Code

ST090

1

82840

1

D4073-1

Manufactured No

110 Each

6.0000

Spr ***D4073-1***
Door Hinge

**

4
2

Location

Loc Qty

Loc Code

ST120

6

82355

6

D4073-3

Manufactured No

110 Each

16.0000

Spr ***D4073-3***
Door Hinge Backing Plate

**

4
2

Location

Loc Qty

Loc Code

ST

-8

82213

1

ST090

15

78527

1

82842

14

ST120

9

D4074-1

Manufactured No

110 Each

4.0000

Spr ***D4074-1***
Bracket

**

2
12/7/31 sf

Location

Loc Qty

Loc Code

ST120

4

76338

4

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86202

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

D4074-3

Manufactured No

110 Each

15.0000

Sr ***D4074-3***
Channel

**

Location

Loc Qty

Loc Code

ST091

15

80696

15

D4074-5

Manufactured No

110 Each

84.0000

Sr ***D4074-5***
Backing Plate

**

Location

Loc Qty

Loc Code

ST120

84

74495

82

76339

2

D4074-7

Manufactured No

110 Each

8.0000

Sr ***D4074-7***
Striker Plate

**

Location

Loc Qty

Loc Code

ST091

8

75624

6

76887

2

D4519-1

Manufactured No

110 Each

9.0000

Sr ***D4519-1***
Relay Bracket

**

Location

Loc Qty

Loc Code

ST114

9

79090

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86202

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

3,570.000

28

56

MS21042I 3

Nut

**

sd

SP

Location

Loc Qty

Loc Code

ST300

1570

117885

32

119017

816

119075

138

121444

584

ST317

2000

122141

2000

41

15

MS21042L5

Purchased

No

110

Each

1,307.000

1

2

MS21042I 5

Nut

**

SP

12/7/06 sd

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

807

108827

4

116105

5

116548

43

117611

14

119109

725

17651

8

2937

8

2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-10

Purchased

No

110

Each

154.0000

8 16

**

MS27039-1-10

Screw

Location

Loc Qty

Loc Code

GA

100

120449

100

ST291

5

120120

5

ST308

49

122027

49

MS27039-1-14

Purchased

No

110

Each

175.0000

2 4

**

MS27039-1-14

Screw

Location

Loc Qty

Loc Code

GA

158

120177

58

120449

100

ST291

17

112312

17

MS27039-1-16

Purchased

No

110

Each

102.0000

8 16

**

MS27039-1-16

Screw

Location

Loc Qty

Loc Code

ST291

102

119902

1

120229

51

121444

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-17

Purchased

No

110

Each

111.0000

0

**

MS27039-1-17

Screw

Location

Loc Qty

Loc Code

GA

96

120142

96

ST291

15

117591

15

110

Each

1,318.000

18

36

**

NAS1149D03631

Purchased

No

NAS1149D0363.1

Washer

Location

Loc Qty

Loc Code

ST298

1318

116025

2

117601

61

118612

3

119537

33

120142

13

120308

17

121243

342

121524

847

110

Each

754.0000

0

2

**

NAS1149D06631

Purchased

No

NAS1149D0663.1

Washer

Location

Loc Qty

Loc Code

ST298

754

121243

8

121444

246

121708

500

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86202

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5L

Purchased

No

110

Each

139.0000

4

8

**

*NAS1515H5I *

WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

99

119902

1

122049

98

IN4007

Purchased

No

110

Each

31.0000

0

2

**

IN4007

Diodes

Location

Loc Qty

Loc Code

ST390

11

120363

11

ST395

20

114970

11

117871

9

M12883/41-19

Purchased

No

110

Each

22.0000

0

2

**

M12883/41-19

Relay Base

Location

Loc Qty

Loc Code

ST395

22

120251

9

122097

13

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-22-12 3:03:56 PM

Page 11

Work Order ID: 86202

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

86202

D139-799-013

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 2.00

Required Qty: 2.00

M39029/92-534

Purchased

No

110

Each

122.0000

4 8

**

sd

8

M39029/92-534

Socket Contact

Location

Loc Qty

Loc Code

ST511

122

120344

33

120363

89

110

Each

22.0000

1 8

**

12/17/26 sd

M83536/9-024M

Purchased

No

M83536/9-024M

Relay

Location

Loc Qty

Loc Code

ST395

22

120251

9

122097

13

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. F AND ICA-D139-799 REV. 5

REF. FAA STC: SR02138SE

REF EASA STC EASA.10038656

PURPOSE

The purpose of this DSI is to clarify the installation of the D139-799-013 Cargo Door Fwd Opening Kit on aircraft that are equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors with two gas springs (see Figure 3b of IIN-D139-799 Rev. F).

PROCEDURE

Amend IIN-D139-799 Rev.F steps as follows:

- 3.2.1.2 Remove left/right hinges from the doors as shown in Figure 3a including the door open switches on the fwd hinge bracket. Remove left/right gas spring hinges (if installed) from the door as shown in Figure 3b. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, remove 3P5230A15631 and 3P5230A15731 hinge brackets from the airframe as shown in Figure 1 of this DSI.
- 3.2.2.10 Install the D4074-7 Striker Plate using 4 x CR3523-4 rivet as shown in Figure 5c Section G-G. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, trim Doorframe Channel as shown in Figure 2 of this DSI to allow space for alternate D4632-1 (LH) and D4632-2 (RH) striker plates. Install alternate D4632-1/-2 striker plate at the aft airframe hinge bracket location (see Figure 2 of this DSI). Transfer drill 4 x holes from 3P5340A31951 doubler to striker plate, and install using MS24694-S47 screw, NAS1149D0332J washer and MS21042L3 nut in 4 places.
- 3.2.2.11 Install D4074-1/-5 Bracket/Backing Plate using the existing holes in the cargo door as shown in Figure 5b Detail E. Plug holes at center of the door used for original gas springs using existing hardware. Torque screws per Table 1. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, plug existing holes with Hysol EA934NA. Locate D4074-1 bracket at bottom of existing recess and transfer hole locations to door as shown in Figure 4 of this DSI. Install D4074-1/-5 brackets using hardware shown in Figure 5b Detail E of IIN-D139-799 Rev. F.
- 3.2.2.12 Install D4074-3 Channel using existing hardware in original gas spring cut out as shown in Figure 5d Section I-I. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, trim Doorframe Cover as shown in Figure 3 of this DSI to expose bottom side of Doorframe Channel. Locate D4074-3 Channel as shown in Figure 3 of this DSI and transfer 4 x $\varnothing 0.173$ " (#17 drill) from the D4074-3 Channel to the Doorframe Channel. Install D4074-3 Channel using MS27039-0807 screw, NAS1149DN832J washer and MS21042L08 nut in 4 places.

PART LIST

Note: The following parts are included in D139-799-013 at CHG 005 and later. For customers who already have D139-799-013 at CHG 004 and earlier, procure the DSI 9613-011 kit from Dart.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9613-011	CARGO DOOR HINGE MOD KIT
1	D4632-1	STRIKER PLATE
1	D4632-2	STRIKER PLATE
8	MS24694-S47	SCREW
8	MS27039-0807	SCREW
8	NAS1149DN832J	WASHER
8	NAS1149D0332J	WASHER
8	MS21042L08	NUT
8	MS21042L3	NUT

WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance

A	NEW ISSUE	RF	12.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9613	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO DOOR HINGE MOD	NTS
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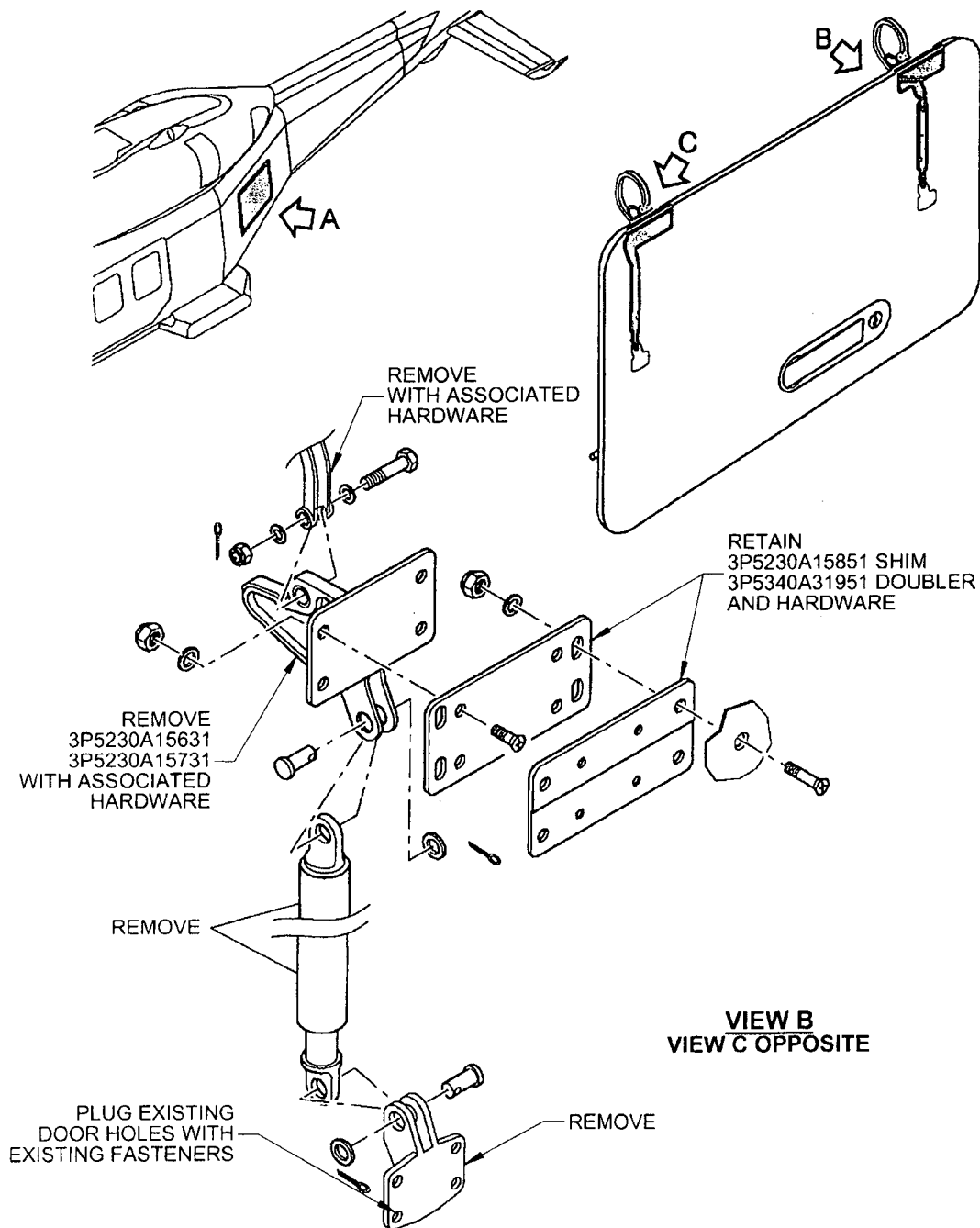
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**FIGURE 1 - REMOVING PARTS FROM THE DOOR LH SHOWN
RH SHOWN OPPOSITE**

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

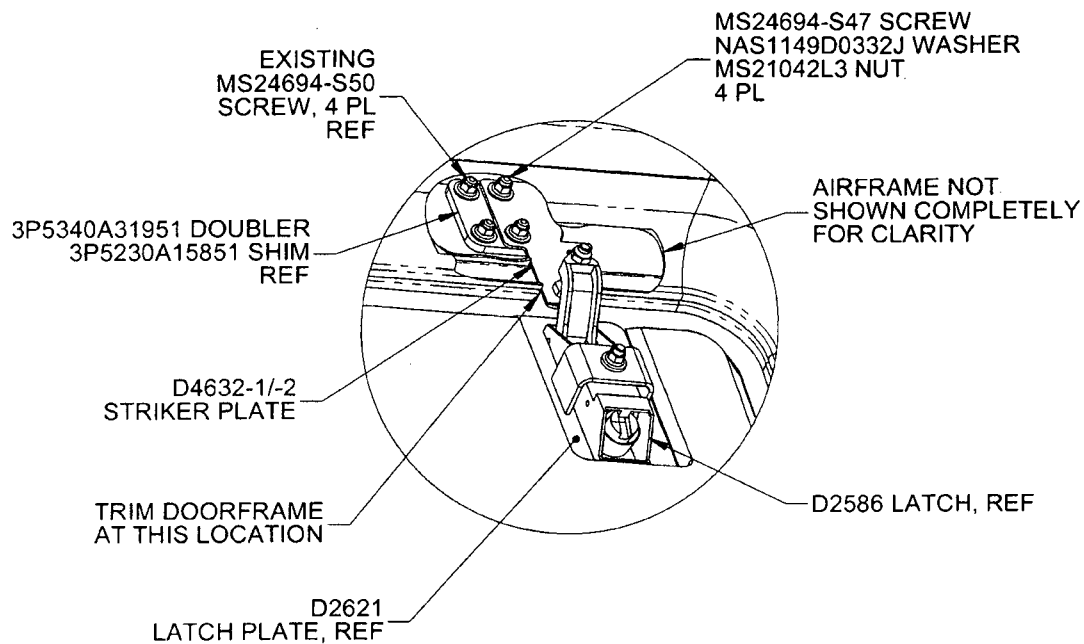


FIGURE 2 - D4632-1/-2 STRIKER PLATE INSTALLATION

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MFG. APPR.	N/A		SHEET 3 OF 5
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

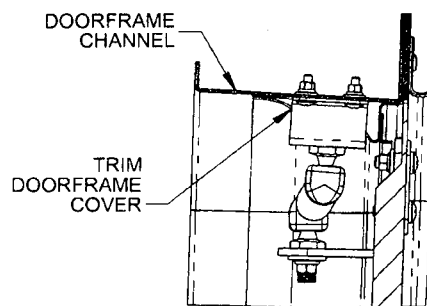
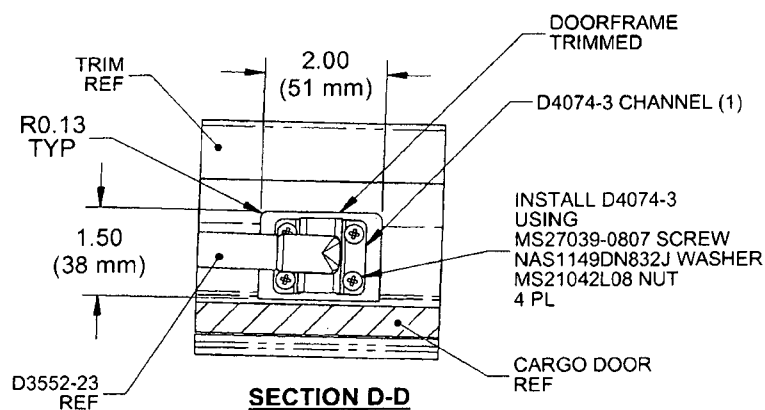
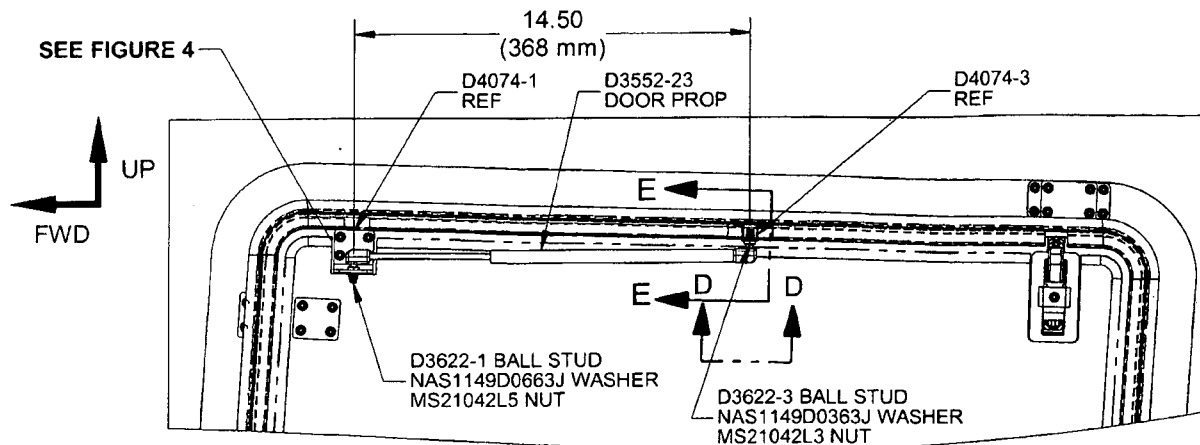


FIGURE 3 - D4074-3 CHANNEL INSTALLATION

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

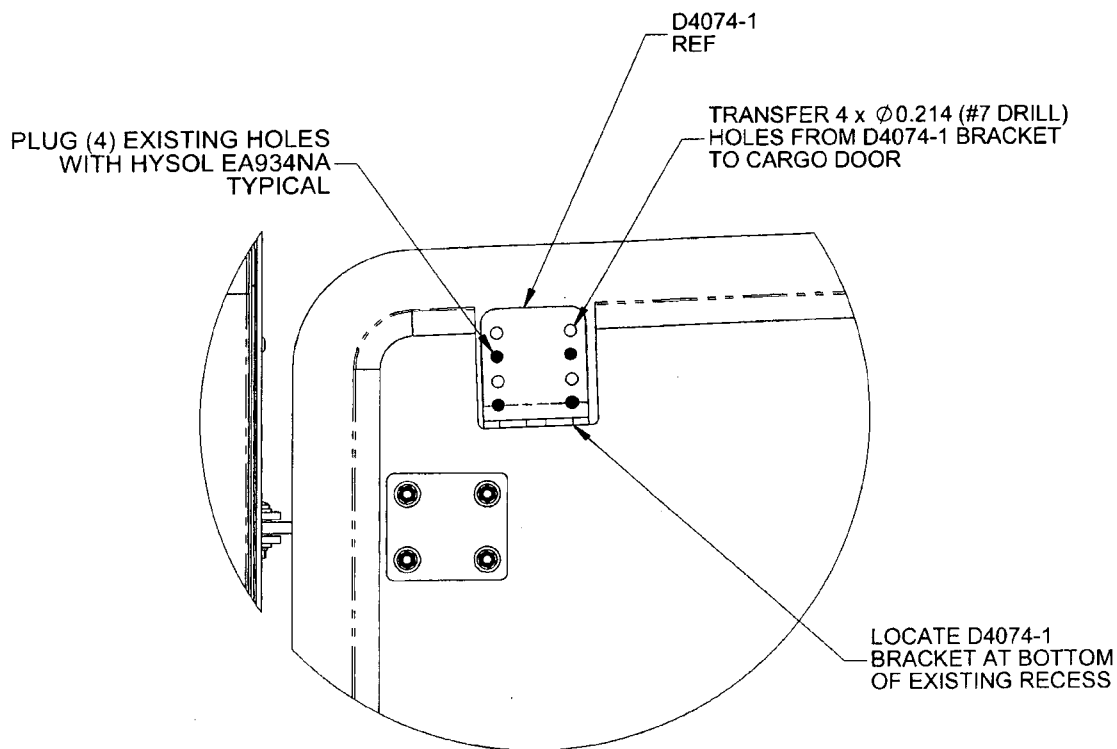


FIGURE 4 - D4074-1 BRACKET INSTALLATION

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MFG. APPR.	N/A		SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO DOOR HINGE MOD	1:12
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. F AND ICA-D139-799 REV. 5

REF. FAA STC: SR02138SE
REF EASA STC EASA.10038656

REFERENCE ONLY
6

PURPOSE

The purpose of this DSI is to clarify the installation of the D139-799-013 Cargo Door Fwd Opening Kit on aircraft that are equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors with two gas springs (see Figure 3b of IIN-D139-799 Rev. F).

PROCEDURE

Amend IIN-D139-799 Rev.F steps as follows:

- 3.2.1.2 Remove left/right hinges from the doors as shown in Figure 3a including the door open switches on the fwd hinge bracket. Remove left/right gas spring hinges (if installed) from the door as shown in Figure 3b. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, remove 3P5230A15631 and 3P5230A15731 hinge brackets from the airframe as shown in Figure 1 of this DSI.
- 3.2.2.10 Install the D4074-7 Striker Plate using 4 x CR3523-4 rivet as shown in Figure 5c Section G-G. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, trim Doorframe Channel as shown in Figure 2 of this DSI to allow space for alternate D4632-1 (LH) and D4632-2 (RH) striker plates. Install alternate D4632-1/2 striker plate at the aft airframe hinge bracket location (see Figure 2 of this DSI). Transfer drill 4 x holes from 3P5340A31951 doubler to striker plate, and install using MS24694-S47 screw, NAS1149D0332J washer and MS21042L3 nut in 4 places.
- 3.2.2.11 Install D4074-1/-5 Bracket/Backing Plate using the existing holes in the cargo door as shown in Figure 5b Detail E. Plug holes at center of the door used for original gas springs using existing hardware. Torque screws per Table 1. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, plug existing holes with Hysol EA934NA. Locate D4074-1 bracket at bottom of existing recess and transfer hole locations to door as shown in Figure 4 of this DSI. Install D4074-1/-5 brackets using hardware shown in Figure 5b Detail E of IIN-D139-799 Rev. F.
- 3.2.2.12 Install D4074-3 Channel using existing hardware in original gas spring cut out as shown in Figure 5d Section I-I. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, trim Doorframe Cover as shown in Figure 3 of this DSI to expose bottom side of Doorframe Channel. Locate D4074-3 Channel as shown in Figure 3 of this DSI and transfer 4 x $\phi 0.173$ " (#17 drill) from the D4074-3 Channel to the Doorframe Channel. Install D4074-3 Channel using MS27039-0807 screw, NAS1149DN832J washer and MS21042L08 nut in 4 places.

PART LIST

Note: The following parts are included in D139-799-013 at CHG 005 and later. For customers who already have D139-799-013 at CHG 004 and earlier, procure the DSI 9613-011 kit from Dart.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9613-011	CARGO DOOR HINGE MOD KIT
1	D4632-1	STRIKER PLATE
1	D4632-2	STRIKER PLATE
8	MS24694-S47	SCREW
8	MS27039-0807	SCREW
8	NAS1149DN832J	WASHER
8	NAS1149D0332J	WASHER
8	MS21042L08	NUT
8	MS21042L3	NUT

WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance

A	NEW ISSUE	RF	12.05.29
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9613	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO DOOR HINGE MOD	NTS
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Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	IN4007	DIODE
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-115	PIN, COTTER